



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3883-2

Job Sheet 168602



Part No: D3883-2

Job Qty: 4 ea **12 MP**

Part Name: Saddle, Outside RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/20/17

Job Tracking No:

Due Date: ~~11/27/17~~ **12 DEC.**

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D IPP RevA: New issue DD verified by:EC IPP REV:B 15.05.20 remove inside powdercoat DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/24/17	11/24/17	0.00	0.00	Start Up Machining		FR 17-12-17
100	CNC Vertical Machining	4 pcs	11/25/17	11/25/17	0.64	9.09	HAAS 1		FR/SBL 17/12/20
110	QC	4 pcs	11/25/17	11/25/17	0.00	0.00	QC2		FR/SBL 17/12/20
120	QC	4 pcs	11/25/17	11/25/17	0.00	0.00	QC8		FR 17-12-20
130	HandFinish	4 pcs	11/25/17	11/25/17	0.00	0.41	HandFinish1		2017-12-20 JSL
140	Powdercoat	4 pcs	11/27/17	11/27/17	0.00	0.15	Powdercoat1		FR 17-12-20
150	QC	4 pcs	11/27/17	11/27/17	0.00	0.00	QC3		PD 17-12-20
160	Packaging	4 pcs	11/27/17	11/27/17	0.00	0.00	Packaging3		AT
170	QC21-SA	4 Ea	11/27/17	11/27/17	0.00	0.00	QC21		AT

Part Op 100 - Program Batch No. _____ 1-Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets
Descriptions: 2-Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA817
and inspect per Dimension Sheets
110 - Inspect on CMM as per folio CMM013.
140 - ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED
ON DWG (SEE NOTE 2)***

M138467. START: 5:30. OUT: 3:20 FINISH: 6:00.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-015	4	11	0	0

Part Specifications

Specifications could not be found.

Plex 11/20/17 8:24 AM dart.lacelle.linda

DART
AEROSPACE
S023639

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Saddle, Outside RH

PART NO: D3883-2

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 12/17/17

Job No: 168602

DART AEROSPACE LTD		Work Order: 168602
Description: Saddle, Outboard, RH		Part Number: D3883-2
Inspection Dwg: D3883	Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875	SBL	
B	1.433	1.443		1.438	1.438	1.438	1.438	SBL	
C	0.638	0.658	(.599)	.645	.644	.644	.643	SBL	
D	3.895	3.905		3.900	3.900	3.900	3.900	SBL	
E	0.257	0.262		.257	.257	.257	.257	SBL	
F	0.605	0.625	(.486)	.614	.614	.612	.611	11	
G	1.120	1.130		1.125	1.125	1.125	1.125	11	
H	2.245	2.255		2.250	2.250	2.250	2.250	11	
I	2.000	2.020		2.000	2.000	2.000	2.000	11	
J	0.140	0.165		.152	.152	.150	.150	11	
K	0.240	0.260		.249	.249	.248	.249	11	
L	0.115	0.135		.123	.123	.123	.124	11	
M	0.140	0.165		.152	.151	.153	.153	11	
N	0.720	0.780		.780	.780	.780	.780	11	
O	0.240	0.260		.253	.253	.250	.251	11	
P	0.110	0.140		.135	.135	.135	.135	11	
Q	0.178	0.198		.188	.188	.188	.188	11	
R	2.825	2.885		2.857	2.855	2.855	2.854	11	
S	0.316	0.321		.316	.316	.316	.316	11	
T	0.990	1.010	(.842)	1.001	1.000	1.000	1.000	11	
U	1.745	1.755		1.750	1.750	1.750	1.750	11	
V	5.990	6.010		6.001	6.001	6.002	6.001	11	
W	1.245	1.255		1.250	1.250	1.250	1.250	11	
X	0.490	0.510		.501	.503	.502	.501	11	
Y	1.220	1.280		1.250	1.250	1.250	1.250	11	
Z	2.495	2.505		2.500	2.500	2.500	2.500	11	
AA	0.313	0.318		.313	.313	.313	.313	11	
AB	0.020	0.040		.030	.030	.030	.030	11	
AC	0.760	0.765		.760	.760	.760	.760	11	
AD	0.215	0.220		.219	.218	.218	.218	11	
AE	1.265	1.285		1.265	1.265	1.265	1.265	11	
AF									
Accept/Reject									

Measured by:	FK SBL
Date:	17-12-18 17/12/19

Audited by:	am
Date:	17-12-20

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	AA

DART AEROSPACE LTD		Work Order: 168602
Description: Saddle, Outboard, RH		Part Number: D3883-2
Inspection Dwg: D3883	Rev. D	Page 1 of 1

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B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.645	0.645	0.648	0.648		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.257	0.257	0.257	0.257		
F	0.605	0.625		0.615	0.615	0.615	0.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.165		0.151	0.151	0.151	0.151		
K	0.240	0.260		0.250	0.248	0.248	0.250		
L	0.115	0.135		0.125	0.124	0.125	0.125		
M	0.140	0.165		0.153	0.152	0.153	0.153		
N	0.720	0.780		0.770	0.770	0.770	0.770		
O	0.240	0.260		0.250	0.250	0.250	0.250		
P	0.110	0.140		0.135	0.135	0.135	0.135		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	2.825	2.885		2.855	2.855	2.856	2.856		
S	0.316	0.321		0.316	0.316	0.316	0.316		
T	0.990	1.010		1.001	1.001	1.000	0.999		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.002	6.001	6.002	6.002		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		0.500	0.500	0.501	0.501		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		0.313	0.313	0.313	0.313		
AB	0.020	0.040		0.030	0.030	0.030	0.030		
AC	0.760	0.765		0.760	0.760	0.760	0.760		
AD	0.215	0.220		0.218	0.219	0.218	0.218		
AE	1.265	1.285		1.265	1.265	1.265	1.265		
AF									
Accept/Reject									

Measured by: SBL	Audited by: am
Date: 17/12/20	Date: 12-12-20

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	AA

DART AEROSPACE LTD		Work Order: 168602
Description: Saddle, Outboard, RH		Part Number: D3883-2
Inspection Dwg: D3883	Rev. D	Page 1 of 1

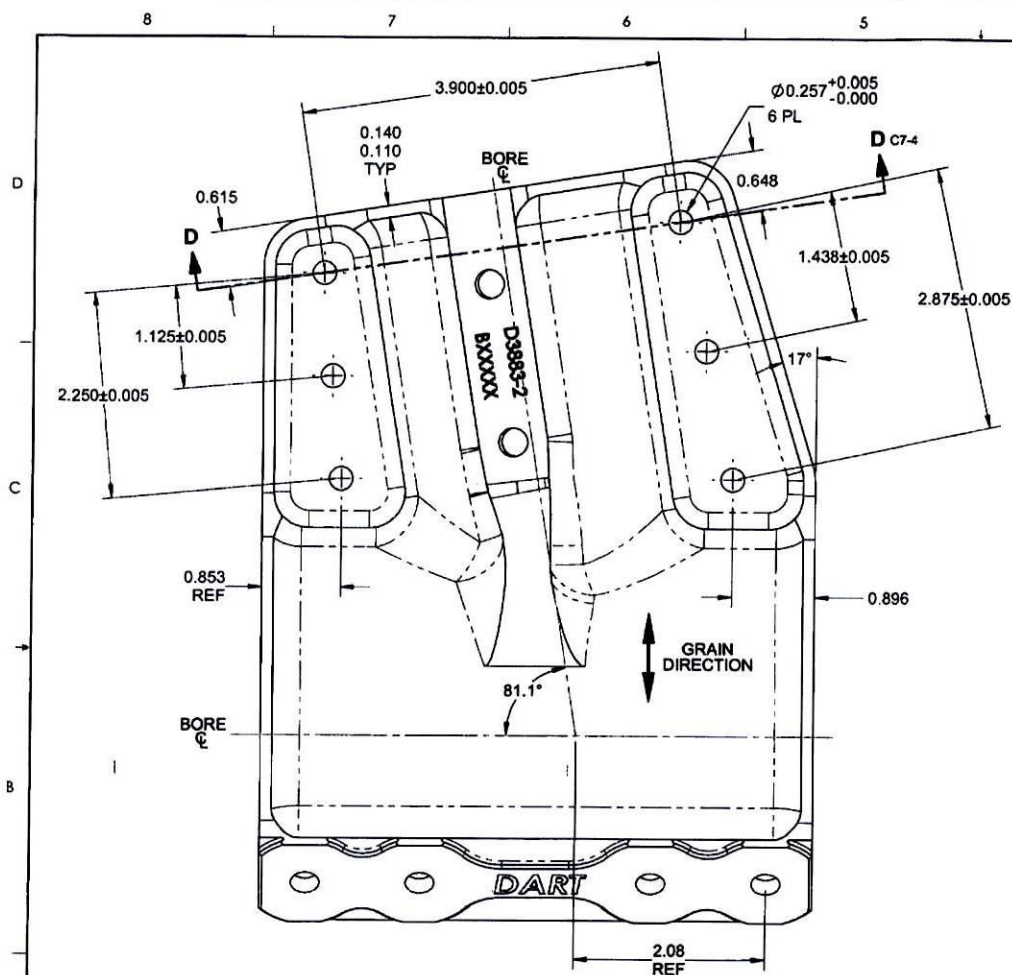
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Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2,875	2,875	2,875	2,875	SBL	
B	1.433	1.443		1,438	1,438	1,438	1,438		
C	0.638	0.658		1,648	1,645	1,645	1,644		
D	3.895	3.905		3,900	3,900	3,900	3,900		
E	0.257	0.262		257	257	257	257		
F	0.605	0.625		613	612	614	611		
G	1.120	1.130		1,125	1,125	1,125	1,125		
H	2.245	2.255		2,250	2,250	2,250	2,250		
I	2.000	2.020		2,000	2,000	2,000	2,000		
J	0.140	0.165		153	151	151	150		
K	0.240	0.260		248	247	247	246		
L	0.115	0.135		124	124	124	125		
M	0.140	0.165		152	151	153	151		
N	0.720	0.780		730	732	770	770		
O	0.240	0.260		249	250	251	249		
P	0.110	0.140		130	135	130	135		
Q	0.178	0.198		188	188	188	188		
R	2.825	2.885		2,855	2,855	2,854	2,856		
S	0.316	0.321		316	316	316	316		
T	0.990	1.010		998	1,000	998	998		
U	1.745	1.755		1,750	1,750	1,750	1,750		
V	5.990	6.010		6,002	6,002	6,001	6,002		
W	1.245	1.255		1,250	1,250	1,250	1,250		
X	0.490	0.510		502	500	504	502		
Y	1.220	1.280		1,253	1,250	1,250	1,250		
Z	2.495	2.505		2,500	2,500	2,500	2,500		
AA	0.313	0.318		313	313	313	313		
AB	0.020	0.040		030	030	030	030		
AC	0.760	0.765		760	760	760	760		
AD	0.215	0.220		218	217	217	218		
AE	1.265	1.285		1,265	1,265	1,265	1,265		
AF									
Accept/Reject									

Measured by: SBL
Date: 17/12/20

Audited by: [Signature]
Date: 17-12-20

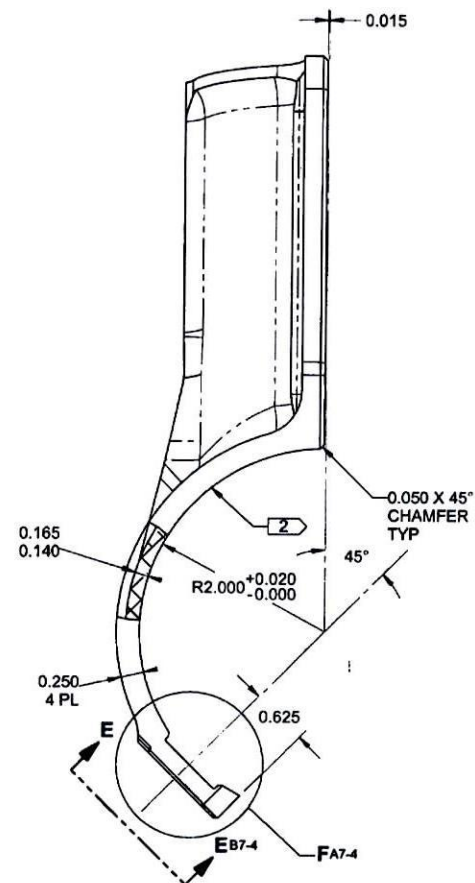
Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	[Signature]



D3883-2 SADDLE, OUTBOARD RH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-2-REVD.SLDPRT"

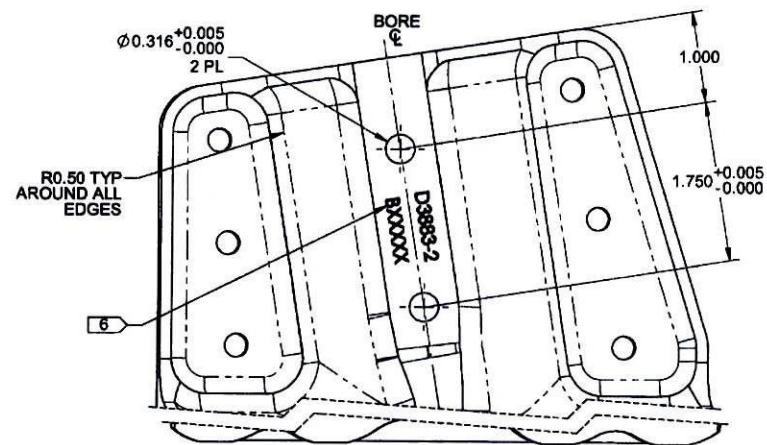
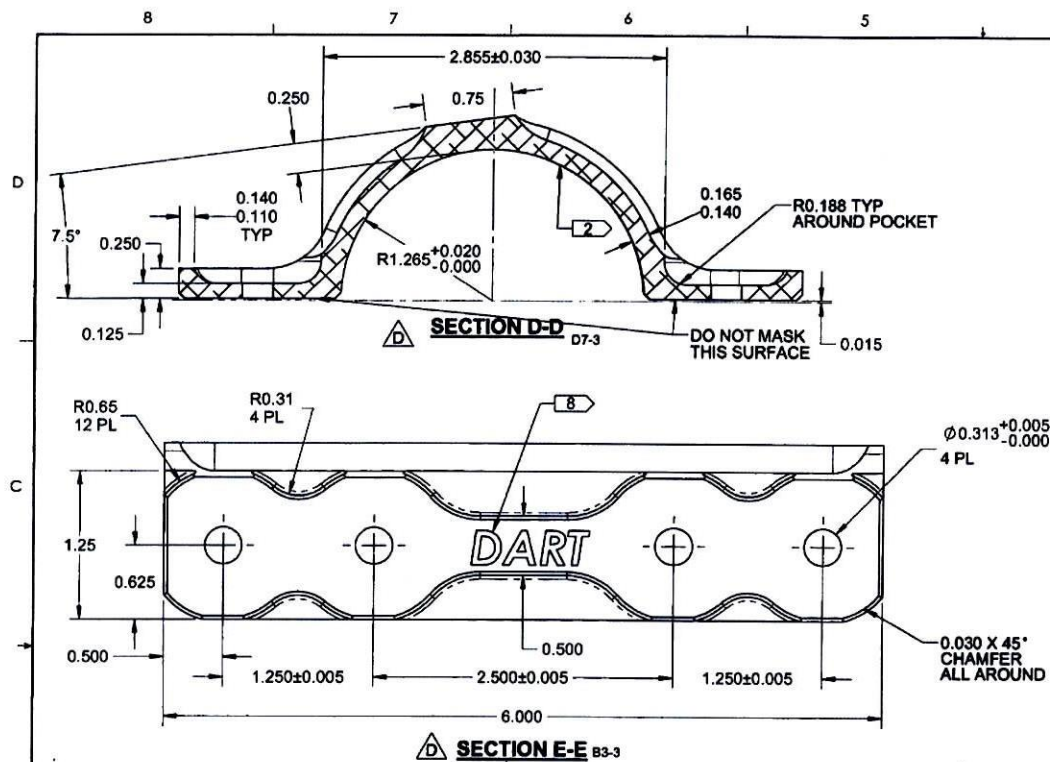


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APR 2015 MAY 19

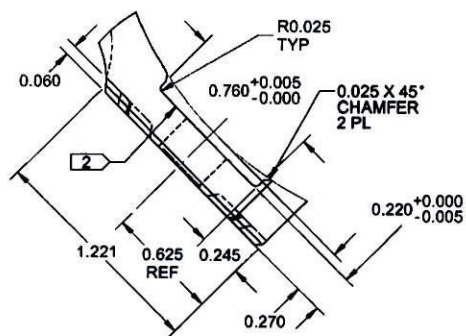
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	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D3883	SHEET 3 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD SADDLE	NTS
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D3883-2 SADDLE, OUTBOARD RH
(AUXILIARY VIEW)



DETAIL F B3-3

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	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD SADDLE	NTS
	DATE	15.02.11	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	